

Work Order ID 77319

December-02-11 12:43:18 PM

*ASAP*

\*77319\*

Page 1

Item ID: D4148-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/02/11 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/05/11 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4148

D

100

0.00

\*100\*

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

*9/11/12/05 (2)*

110

QC5- Inspect part completeness to step on W/O

0.00

\*110\*

QC

Memo

0.00

Quality Control

*Sulizlor*

*(+2)*

120

Identify as per dwg & Stock Location: *468*

0.00

\*120\*

Packaging

Memo

0.00

Packaging

*12/11/12/05 (2)*

**Work Order ID 77319**

December-02-11 12:43:18 PM

**\*77319\***

Page 2

Item ID: D4148-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/02/11 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/05/11 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

11/12/15  
MF  
11-1205

# Picklist Print

December-02-11 12:43:17 PM

Page 1

Work Order ID: 77319

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/02/11

Required Date: 12/05/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 10.07.22 as per revB DD verf:JLM  
DD verf:EC IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC  
IPP Rev:C 10.10.29 as per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 Nut		Purchased	No			100	Each	876.0000	4	4		11/12/05	

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	804	
118077	1	
118614	449	
118686	124	
119758	230	

MS21043-4 Nut		Purchased	No			100	Each	1.426.0000	1	6		11/12/05	
------------------	--	-----------	----	--	--	-----	------	------------	---	---	--	----------	--

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1386	
117793	3	
118686	470	
119309	413	
119546	500	

D2690-6 Lanyard Assembly		Manufactured	No			100	Each	20.0000	1	2		11/12/05	
-----------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location	Loc Qty	Loc Code
ST020	20	
74515	20	

# Picklist Print

December-02-11 12:43:17 PM

Page 2

Work Order ID: 77319

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/02/11

Required Date: 12/05/11

Start Qty: 2.00

Required Qty: 2.00

D3910-1 Manufactured No  
Crosstube Lug

100 Each 23.0000

1 2

Location	Loc Qty	Loc Code
ENG	2	
70160	2	
st507	21	
73527	21	

*EP 11/12/05*

D4091-1 Manufactured No  
Mounting Lug

100 Each 5.0000

1 2

Location	Loc Qty	Loc Code
ST460	5	
69605	5	

*EP 11/12/05*

D4148-1 Manufactured No  
Crosstube Lug Plate, Fwd

100 Each 9.0000

2 4

Location	Loc Qty	Loc Code
ST133	9	
70161	9	

*EP 11/12/05*

D4148-3 Manufactured No  
Stud Receiver, Lower

100 Each 6.0000

1 2

Location	Loc Qty	Loc Code
ST133	6	
69616	3	
70856	3	

*EP 11/12/05*

D4148-5 Manufactured No  
Eyebolt Stud

100 Each 8.0000

1 2

Location	Loc Qty	Loc Code
ST119	8	
71932	8	

December-02-11 12:43:18 PM

Shop Packet Print

Page 2

# Picklist Print

December-02-11 12:43:18 PM

Page 3

Work Order ID: 77319

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/02/11

Required Date: 12/05/11

Start Qty: 2.00

Required Qty: 2.00

AN3C12A Purchased No

100 Each 98.0000 2 4

Bolts

Location	Loc Qty	Loc Code
ST351	98	
117514	4	
118112	5	
118422	17	
118451	22	
119510	50	

*EB 11/12/05*

AN4C13A Purchased No

100 Each 30.0000 3 6

BOLT

Location	Loc Qty	Loc Code
ST357	30	
118838	30	

*EB 11/12/05*

MS17984-C413 Purchased No

100 Each 17.0000 1 2

PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST315	17	
114340	1	
118612	2	
119307	4	
119623	10	

*EB 11/12/05*

MS20615-4M18 Purchased No

100 Each 476.0000 8 16

Rivet

Location	Loc Qty	Loc Code
ST323	476	
118077	291	
118543	185	

*EB 11/12/05*

December-02-11 12:43:18 PM

Shop Packet Print

Page 3

# Picklist Print

December-02-11 12:43:18 PM

Page 4

Work Order ID: 77319

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/02/11

Required Date: 12/05/11

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R Purchased No

100 Each 5,634.0000 4 8

Washer

Location

Loc Qty

Loc Code

ST297

5634

118354

765

119124

62

119736

4807

NAS1149C0432R Purchased No

100 Each 4,356.0000 6 12

Washer

Location

Loc Qty

Loc Code

ST297

4356

117291

3356

119124

1000

GP 11/12/05

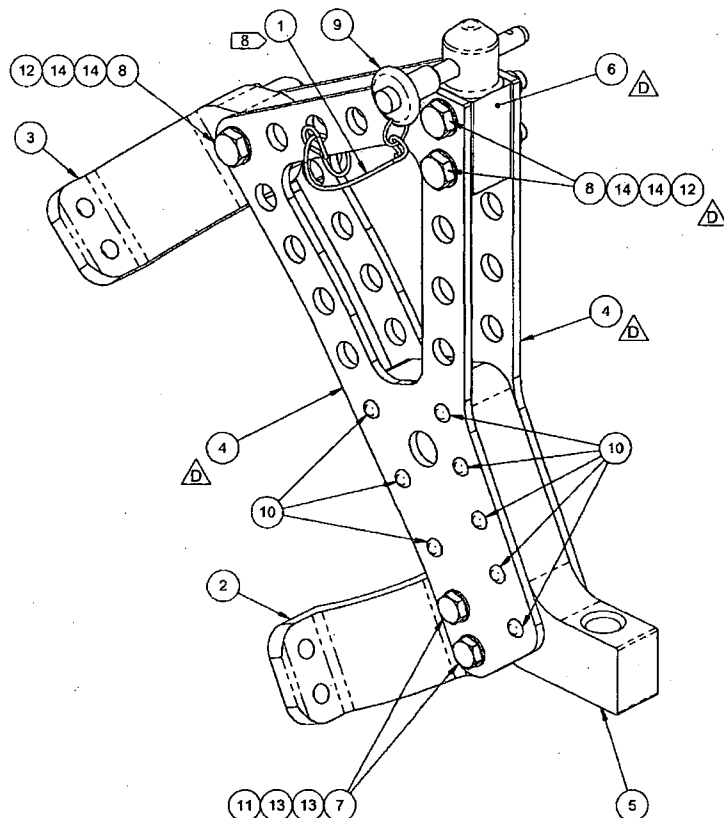
GP 11/12/05

December-02-11 12:43:18 PM

Shop Packet Print

Page 4

8 7 6 5 4 3 2 1



**D4148-041 FWD X-TUBE LUG ASSY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

**RELEASED**  
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D6-3); HOLE DIA CHANGED TO 0.260" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
  - 7) WEIGHT: 3.67 lbs
  - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

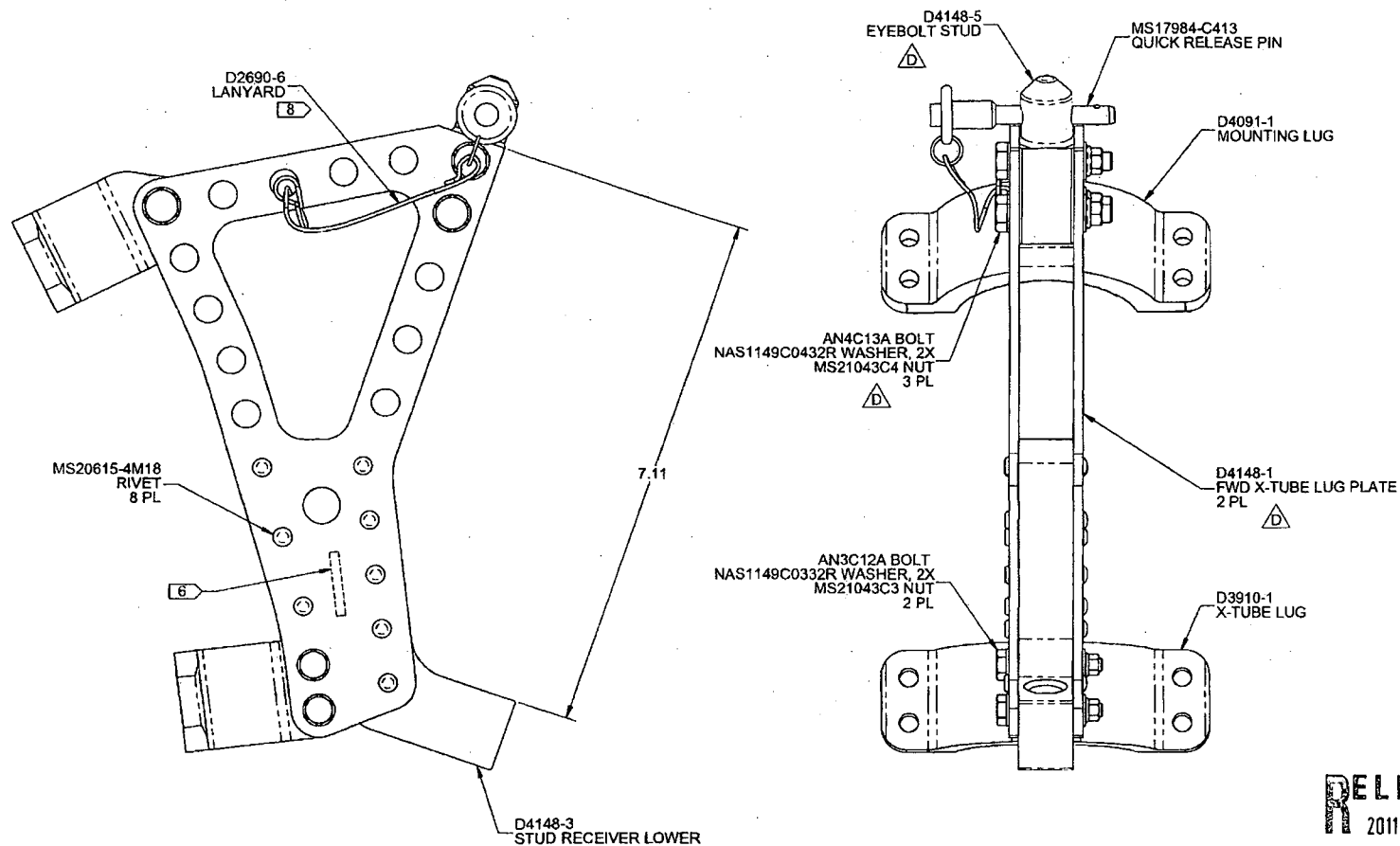
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. D  
SHEET 1 OF 5

TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



**D4148-041 FWD X-TUBE LUG ASSY**

**RELEASED**  
2011-02-24

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4148</b>	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>FWD X-TUBE LUG ASSY</b>	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



